

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024175**Date Inspected:** 31-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

Repair welding of weld joint no: Seg3015K-211 [I-rib stiffener on vertical plate to Floor Beam, complete joint penetration (CJP) weld at panel point (PP) 122.5]. The welder is identified as 045196 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): 21024 Rev-0.

OBG Seg 13BW:

The SMAW process on weld joint no: Seg 3014F-317 (I-rib stiffener splice weld) CJP weld at PP121). The welder

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## WELDING INSPECTION REPORT

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is identified as 067947 and was observed welding in 3G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

Repair welding of weld joint no: Seg3014D-306 (I-rib stiffener to Floor Beam, CJP weld at PP121.5). The welder is identified as 066156 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per WRR: 20261 Rev-0.

Seg 14W:

Repair welding of weld joint no: Seg3020AV-011 (Floor Beam to Deck Panel, CJP weld at PP128.3). The welder is identified as 067571 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per WRR: 21133 Rev-0.

Repair welding of weld joint no: Seg3020D-038 (Deck panel diaphragm, CJP splice weld). The welder is identified as 058245 and was observed welding in the 3G position. Welding process was identified as Flux cored Arc Welding (FCAW). ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-3G(3F)-FCM-Repair-ESAB. Repair welding was done as per Critical Welding Repair report (CWR): 2997 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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